



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA25A-200
Job Sheet 180045



Part No: SWA25A-200

Job Qty: 3 ea ^{DAS} 21 ₉₋₈₀

Part Name: Upper End Swivel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/28/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA25A-200 REV:6 IPP REV A 18.02.20 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		7/6/18	0.00	0.00	Start Up Machining-3		
110	Mori Seiki	2 pcs		7/6/18	0.00	2.00	MORI NLX		
120	QC	2 pcs		7/6/18	0.00	0.00	QC2		
122	Mori Seiki	2 pcs		7/6/18	1.00	1.00	MORI NV5000-1		
124	QC	2 pcs		7/6/18	0.00	0.00	QC2 Machining-2		
130	QC	2 pcs		7/6/18	0.00	0.00	QC8		
140	Packaging	2 pcs		7/6/18	0.00	0.00	Packaging3		
150	QC21-SA	2 Ea		7/6/18	0.00	0.00	QC21		

Part Op 110 - Cut Blanks AT 7.00" 1-Machine as per DWG. FC144 FOLIO REV: AA DWG REV: 621
Descriptions: 2-Debur ***Machine engrave up arrow*** 3-***Please see PEC to change engraving batch # for every w/o***
122 - 1-Machine as per DWG. FC144 FOLIO REV: _____ DWG REV: _____ 2-Debur

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R3.500	17-4 SS H1150 Round Bar 3.500"	1.1660 ft (.583 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H1150-R3.500	1	5	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
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Plex 6/28/18 8:59 AM Dart.lajeunesse.marie

Container No: S094923



Part: SWA25A-200

Job No: 180045

Serial No/Batch: S094923

Revision: 6

Inspector:

Exp Date:

Instructions:

Date: 07/23/18

Luc

Hhrs 4.25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

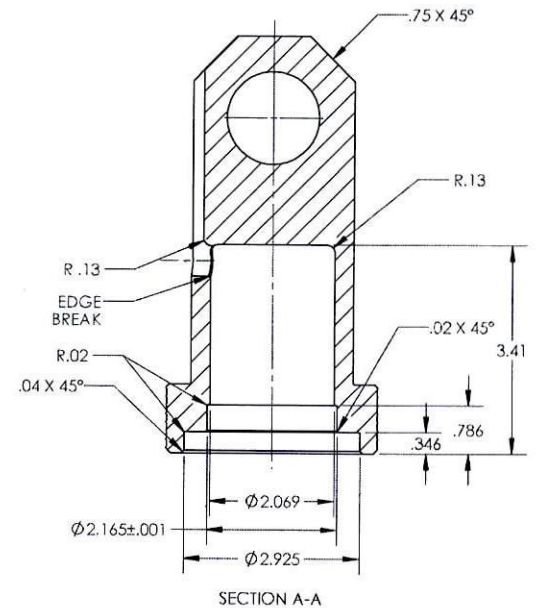
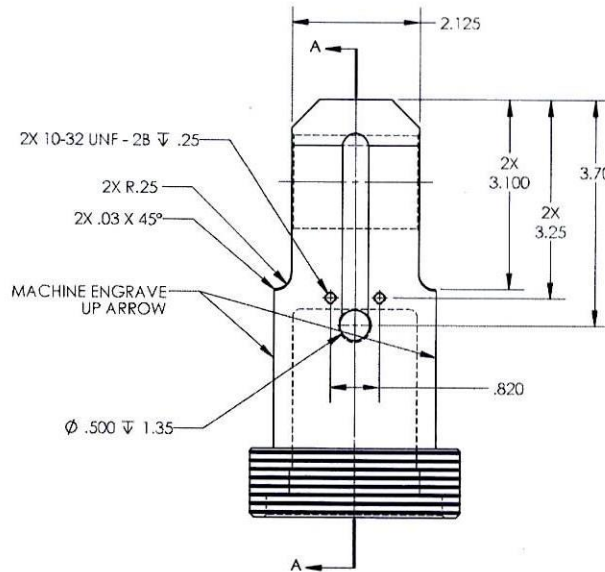
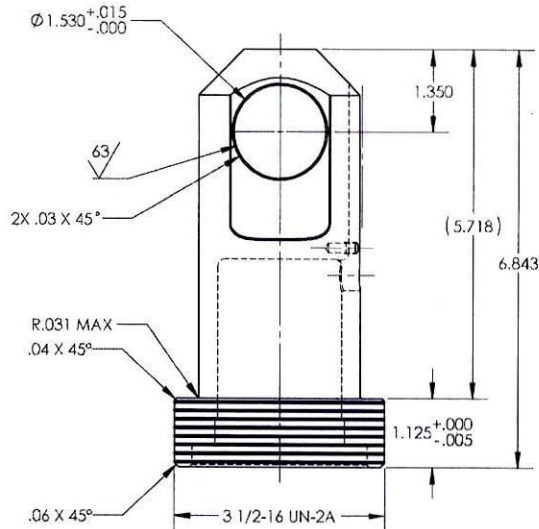
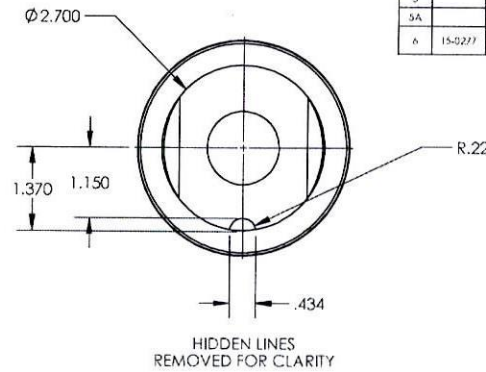
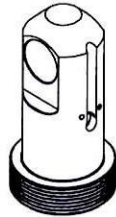
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation		Disposition			

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due	☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter	FAULT CATEGORY ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence
OTHER : _____					

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
5		AS DRAWN BY CANAM	11/12/2012	JAG
5A		CHD B/O INFO TO BLANK	4/29/2014	JAG
6	15-0227	UPDATED TO NEW DRAFTING STANDARDS. ADDED UP ARROW NOTE. ADDED MATL OPTION H1075. ADDED DIMS FROM SWA10A-200 BLANK DWG.	9/22/2015	DPD



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA25A-200	1	UPPER END SWIVEL	SS 17-4, H1150/H1075	

DART AEROSPACE	
TITLE UPPER END SWIVEL	
DWG NO. SWA25A-200	REV 6
MATL GG 17-4, H1150/H1075	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1	APPROVED <i>D. Wild</i> REVIEW FINISH SPEC
1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 1:2	DATE 2/22/2002
SHEET 1 OF 1	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐					

DART AEROSPACE LTD		Work Order: 150.045
Description: Upper end Swivel		Part Number: SWA25A-200
Inspection Dwg: SWA 25A-200	Rev: 6	Page 1 of 2

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.530	+0.015 / -0.000	1.5335			Mic LPO5	
.03 x 45°	+/- .01 x .5°	.03 x 45°			Vern LPO9	
R.031	+0.000 / -0.005	0.031 .03			↓	
.04 x 45°	+/- .01 x .5°	.04 x 45°			↓	
3 1/2 -16 UN-2A						
Max Ø3.4936	+/- .0047	3.494			104-137	
Wire Ø .040					↓	
DDW 3.5207	+/- .0029	3.520			↓	
1.125	+0.000 / -0.005	1.122			M LPO2	
6.843	+/- .005	6.840			HG	
1.350	+/- .005	1.350			↓	
Ø2.700	+/- .005	2.700			Vern LPO9	
1.150	+/- .005	1.152			↓	
.434	+/- .005	.437			↓	
R.22	+/- .01	.219			↓	
10-32 UNF-2B	G-D - No Gro	G-D			↓	
.25	+/- .01	.25			↓	
R.25	+/- .01	.25			↓	
Ø.500	+/- .005	.500			↓	
1.35	+/- .01	1.350			HG	
.820	+/- .005	.822			Vern LPO8	
3.70	+/- .01	3.700			HG	
3.25	+/- .01	3.250			↓	
3.100	+/- .005	3.100			↓	
2.125	+/- .005	2.125			Vern LPO8	
.75 x 45°	+/- .01 x .5°	.755 x 45°			↓	
R.13	+/- .01	R.125				
.04 x 45°	+/- .01 x .5°	.04 x 45°			Vern LPO8	

Measured by: J. J. J.	Checked by: B. A.	QC Inspector:
Date: 14-07-23	Date: 18-07-30	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DART AEROSPACE LTD		Work Order:	180 045
Description: upper end Swivel		Part Number:	
Inspection Dwg:	Rev: 6		Page 1 of 1